

500N

Work Order ID 74503



Monday, October 03, 2011 10:39:31 AM

Item ID: D2935

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 9/30/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2935

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2935

6061.080

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B11-10-4

37

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-10-4

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5.11.10/04

counted
x37

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Sequence ID/
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Set Up/
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Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

37 of 37 photos

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

37XØ M. 11/10/05

150

Identify as per dwg & Stock Location: 027

0.00



Packaging

Memo

0.00

Packaging

11/10/05 (37)

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/10
ME
11-10-10

Picklist Print

Monday, October 03, 2011 10:39:28 AM

Page 1

Work Order ID: 74503

Parent Item: D2935

Parent Item Name: Saddle Spacer



Start Date: 9/30/2011

Required Date: 9/30/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP A: 00.06.06 New Issue: EC: 1
IPP Rev: B Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

348.3000

0.0507

1.601053



1311-10-4

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

348.3

117285

19.3

119009

171

119028

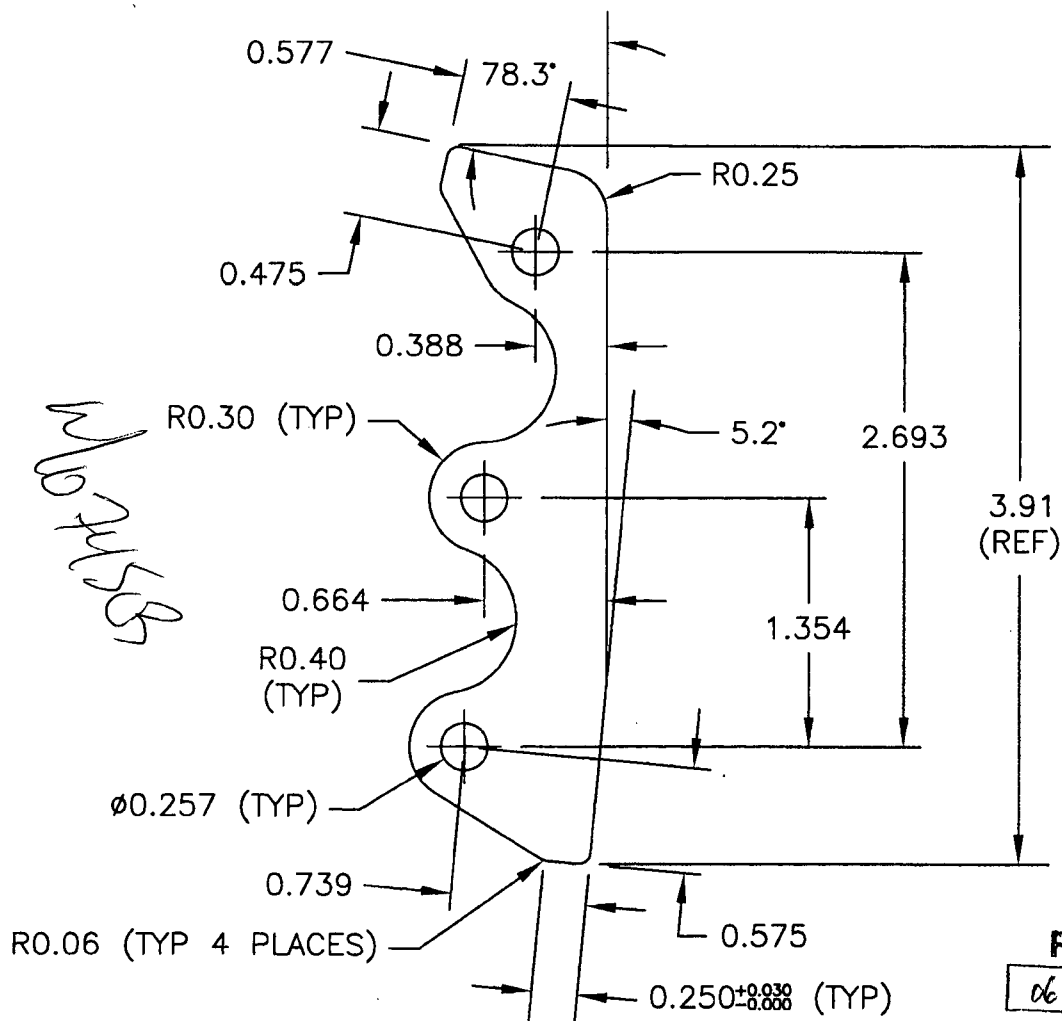
158

119028

637

DART

DESIGN JH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2935	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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